

Date: Friday, 6/1/2007 1:02:33 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	GASKET
Job Number	32740		
Estimate Number	12789		
P.O. Number	N/A	Part Number	D35531
This Issue	6/1/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3553 REV A
First Issue	N/A	Project Number	N/A
Previous Run	31630	Drawing Revision	A
Written By		Material	N/A
Checked & Approved By	<u>KJ</u> 07.06.01	Due Date	6/8/2007
Comment	Est Rev:A New Issue 07-03-08 ec	Qty:	20
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MNE060S063	NEOPRENE SHEET 0.063
Comment: Qty.: 0.1103 sf(s)/Unit Total : 2.2050 sf(s) NEOPRENE SHEET 0.063		mL 07 06 02 (20)
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3553 Dwg Rev: N Prog Rev: A		mL 07 06 02 (20)
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		mL 07 06 02 (20)
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		SA 07.06.04 (20)
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32740

Part Number: D35531

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



ad

Comment: FINAL INSPECTION/W/O RELEASE

107106104

Job Completion



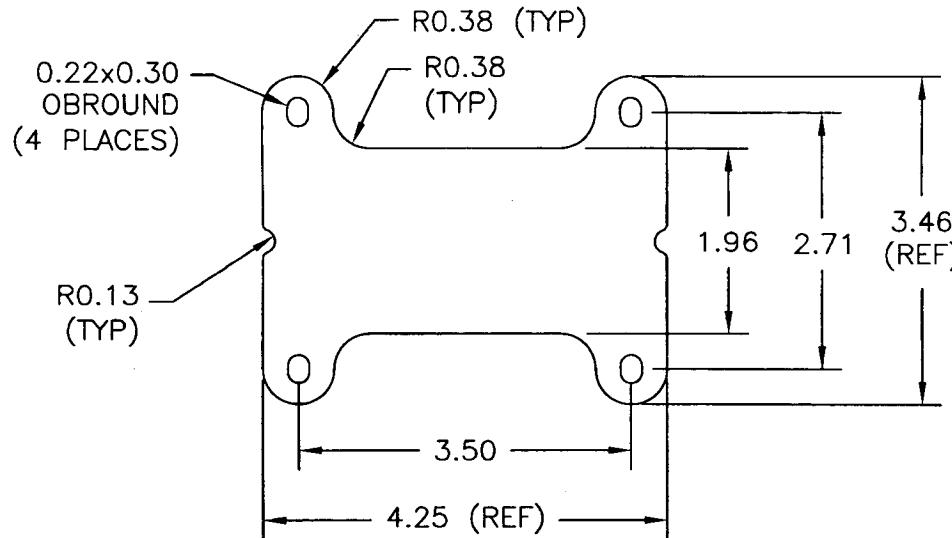
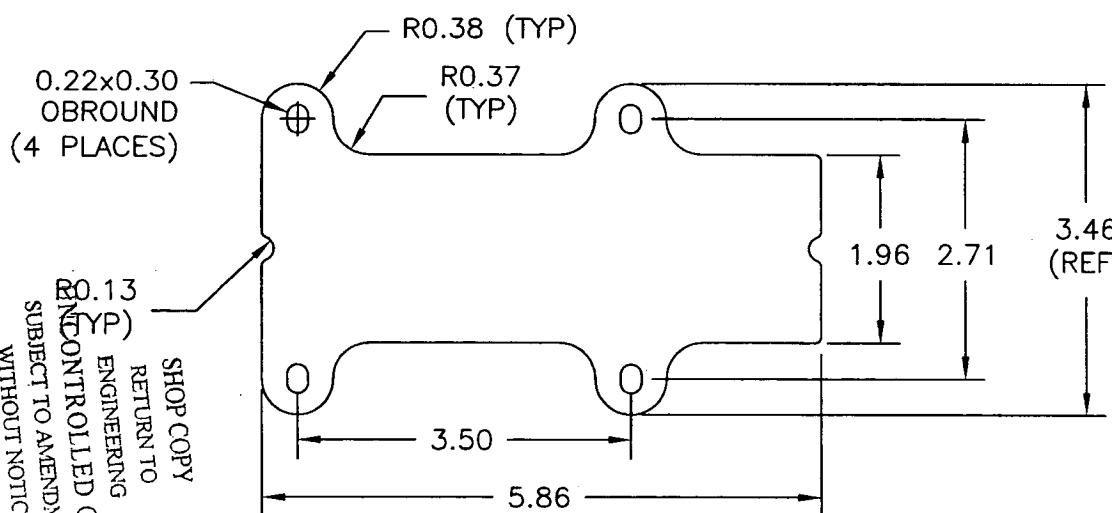
U 07-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTRELEASED
07.02.28**D3553-1 GASKET****D3553-3 GASKET**

NO. 32740

D3553-1/-3 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF. DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC.	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	PORT HADLOCK, WA	
DATE 07.01.11	DRAWING NO. D3553	TITLE GASKET	REV. A SHEET 1 OF 1 SCALE 1:2
A	07.01.11	NEW ISSUE	

DART AEROSPACE LTD

Work Order: 32740

Description: Gasket

Part Number: D3553-1

Inspection Dwg: D3553

Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.22X 0.30	+/- 0.030	0.23X0.310	✓		Vern	
B 3.46	+/- 0.030	3.45	✓		Vern	
C 2.71	+/- 0.030	2.72	✓	/	Vern	
D 1.96	+/- 0.030	1.973	✓		Vern	
E 3.50	+/- 0.030	3.49	✓		Vern	
F 4.25	+/- 0.030	4.24	✓		Vern	
G R0.38	+/- 0.030	R0.38	✓		Vern	
H RO.13	+/- 0.030	RO.13	✓		Vern	
I						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	<i>MM MM</i>	Audited by:	<i>SD</i>	Prototype Approval:	N/A
Date:	07.06.02	Date:	07.06.04	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

JK